

Work Order ID 66193

Monday, February 07, 2011 11:58:07 AM



Page 1

Item ID:	D2324-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bar					
Start Date:	2/8/2011	Start Qty:	10.00		Cust Item ID:	
Required Date:	2/22/2011	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	<i>WLF</i>	Date:	<i>11-02-07</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2324	Rev C								

100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: (0.75" x 0.75") x 5.75" Long Bar								

10
11/03/07

110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1- Machine as per Folio D2324-3 and Dwg D2324-2- Deburr and Tumble to remove sharp edges Identify as D2324-3								
	<i>Manual Mill</i>								

10
11/03/07

120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

10
11/03/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66193

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Item ID: D2324-3

Accept

Revision ID:

Item Name: Bar

Start Date: 2/8/2011 Start Qty: 10.00

Required Date: 2/22/2011 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

SL 11/03/08

10

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10 BR 11-2-9

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 0 11/03/09

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Work Order ID 66193

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Item ID: D2324-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar

Start Date: 2/8/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Packaging

Identify as per dwg & Stock Location: CA

0.00

Memo

0.00

Packaging

170



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

6/3/2 (10)

11/03/9 DJ

PL 11-03-9 (10)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, February 07, 2011 11:58:04 AM

Page 1

Work Order ID: 66193



Parent Item: D2324-3



Parent Item Name: Bar

Start Date: 2/8/2011

Required Date: 2/22/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: E03.02.28 Reformat; Incorporated D2324-3 & D2324-5 KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X00.75 0		Purchased	No			100	f	18.4410	0.53	5.578947			



6061-T6 Bar .750 x .750

Location	Loc Qty	Loc Code
MAT02	6.44095	
108877	1.62	
112567	2.9683	
114993	1.85265	
MAT028	12	
114968	12	

~~6.0~~ 11/03/07
6.0

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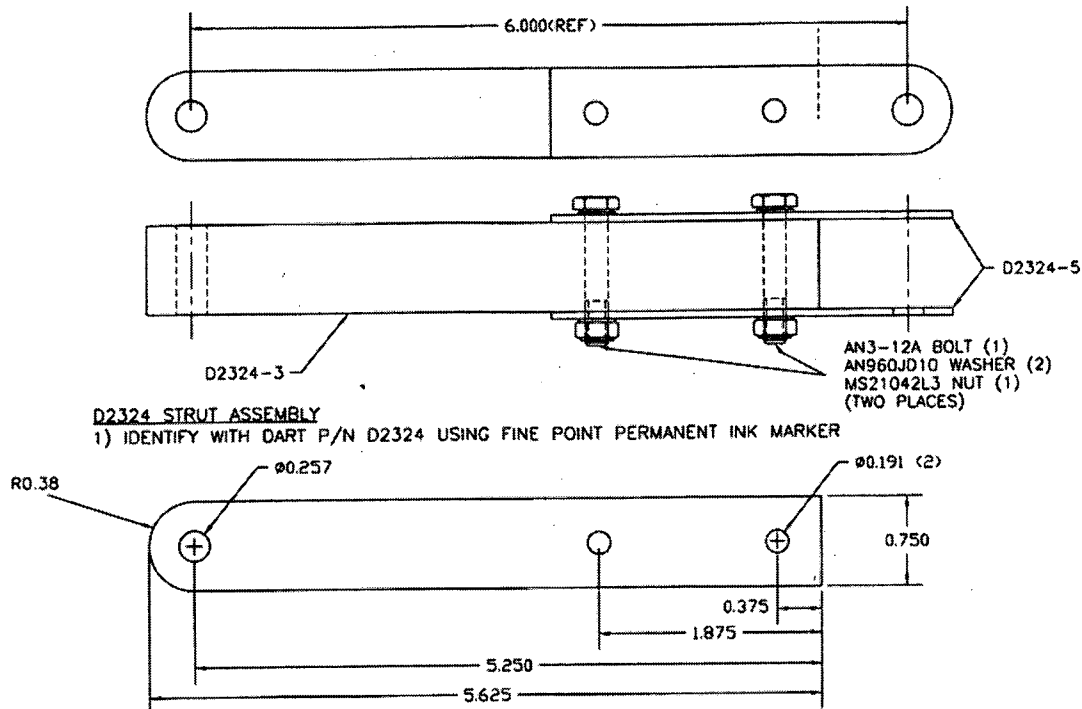
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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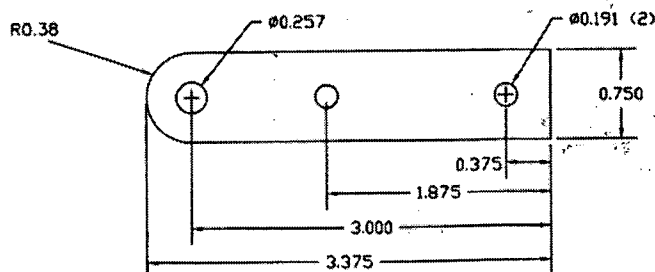
NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO.	REV. C
		D2324	SHEET 1 OF 1
DATE		TITLE	SCALE
04.12.14		STRUT	
A	94.11.08	NEW ISSUE	
B	96.05.07	UPDATE MATERIALS	
C	04.12.14	UPDATE NOTES	

RELEASED04.12.16 *[Signature]***D2324-3**

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X0.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2324-5**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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